

Work Order ID 71270

Friday, June 24, 2011 3:43:12 PM



Page 1

Item ID: D3953-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Gas Spring Stud, Base

Start Date: 6/24/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3953

C

100

0.00



Doosan

Memo

0.00

Doosan Lathe

Turn as per folio FA853 & DWG

FOLIO REV: AE

DWG REV: E

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71270

Friday, June 24, 2011 3:43:12 PM



Page 2

Item ID: D3953-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Gas Spring Stud, Base

Start Date: 6/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11/7/12		22	6		
130 Packaging Packaging	Identify as per dwg & Stock Location: 096 Memo	0.00 0.00							
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11/7/12 20

11/7/13

me

11-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, June 24, 2011 3:43:18 PM

Page 1

Work Order ID: 71270

Parent Item: D3953-5

Parent Item Name: Gas Spring Stud, Base



Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC
DD 10.03.02 verified by:EC

IPP Rev:B as per dwg revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304R1.750

Purchased

No

100

f

23.3830

0.125

1.578947



304 ROUND BAR 1.750



10-7-11

Location

Loc Qty

Loc Code

MAT029

23.383

113295

12.04

117030 ✓

11.343

2.733

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71270
Description: Gas Spring Stud, Base		Part Number:	D3953-5
Inspection Dwg: D3953	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.813	+/-0.010	.813	/		RR .02	
Ø0.194	+0.004/-0.001	.194	/			
0.75	+/-0.030	.749	/			
0.375	+/-0.010	.375	/			
0.38	+/-0.030	.38	/			
0.875	+/-0.010	.875	/			
1.63	+/-0.030	1.630	/		"	
1/4-28 UNF-2A	Max = 0.2668 Min = 0.2635	.264	/		RR .02	
R0.06	+/-0.030	R0.06	/		RR .02	
Ø0.098	+0.004/-0.001	.097	/		"	
0.250	+/-0.010	.2435	/		RR .02	
0.170	+/-0.010	.170	/		RR .02	
0.330	+/-0.010	.330	/			
0.13	+/-0.030	.124	/			
1.44	+/-0.030	1.444	/		"	

Measured by: RR	Audited by: SA	Prototype Approval:	N/A
Date: 11-7-11	Date: 11/7/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.11.11	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ	

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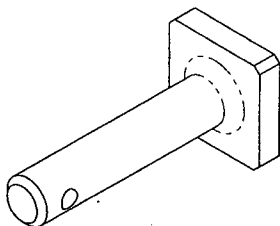
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71278

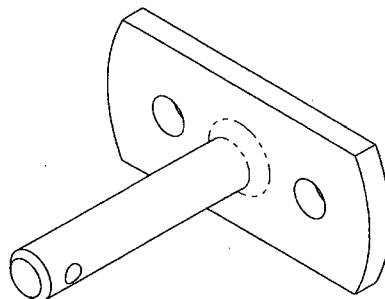
REL 11-06-27



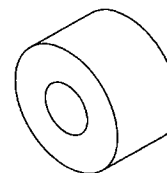
D3953-1 GAS SPRING BRACKET
(FULL LID)



D3953-3 GAS SPRING STUD, LID



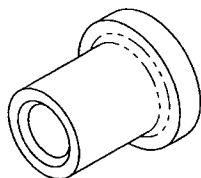
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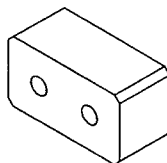
D3953-7 GAS SPRING SPACER



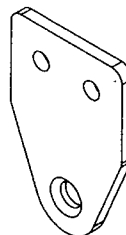
D3953-9 GAS SPRING WASHER



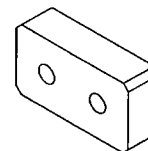
D3953-11 GAS SPRING SPACER



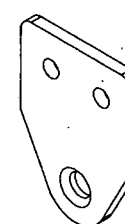
D3953-13 GAS SPRING SPACER
(FULL LID)



D3953-15 GAS SPRING BRACKET
(SPLIT LID)

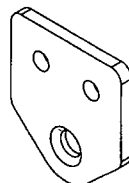


D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)

RELEASED
R 2010-02-26



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

C	PARTS -19 & -21 ADDED (SHT 1 & 4); CSK CALLOUT WAS CHAIN (C6-2, B6-3, C6-4); C SYMM WAS C SYM ABOUT C7-2, C7-4; SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MINMAX REMOVED TOLERANCE ADDED REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

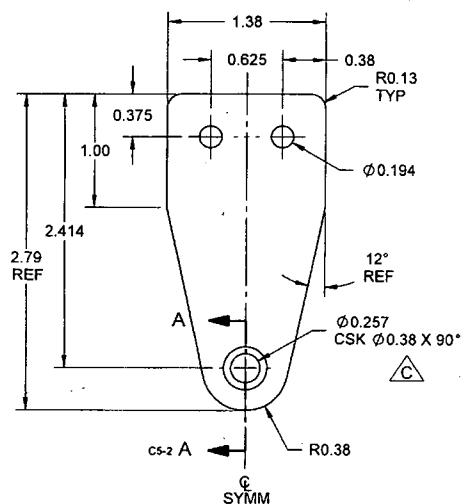
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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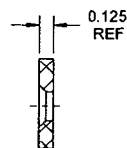
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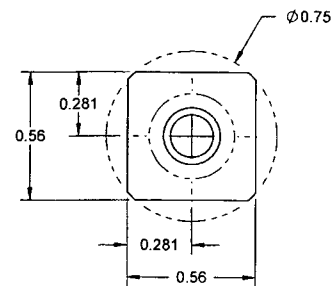
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2010-02-26



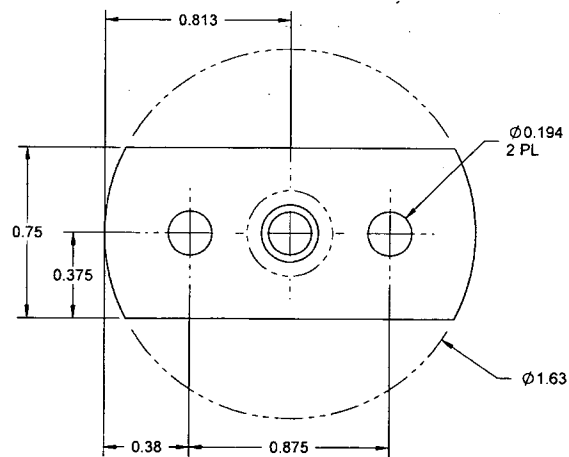
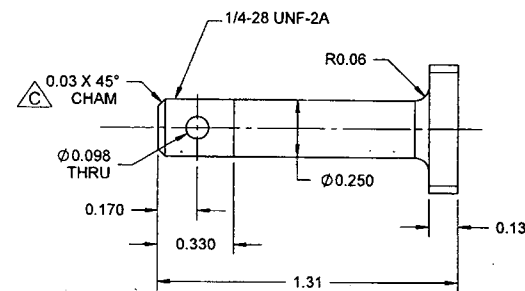
D3953-1 GAS SPRING BRACKET
(FULL LID)



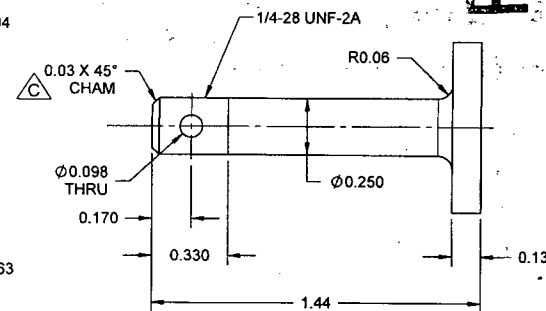
SECTION A-A C7-2



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE



NOTES:

1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
OR:
AIS1 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.11 lbs

-3: 0.03 lbs

-5: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3953 TITLE GAS SPRING LID COMPONENTS COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATELY AND UNCLASSIFIED. IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT THE WRITTEN AUTHORIZATION OF DART AEROSPACE LTD.	REV. C
DRAWN	JPH		SHEET 2 OF 4
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.01.29		

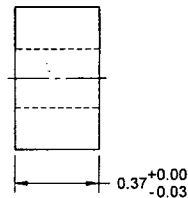
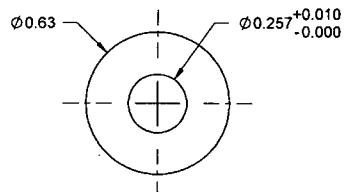
WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

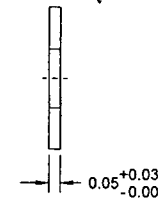
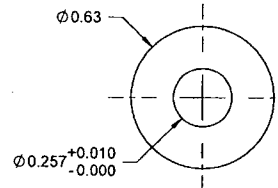
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

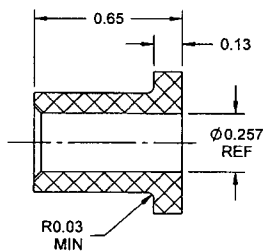
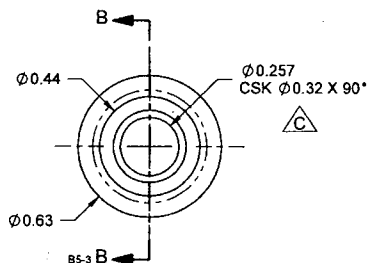
NOTE: Date & initial all entries



D3953-7 GAS SPRING SPACER

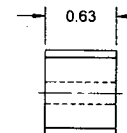
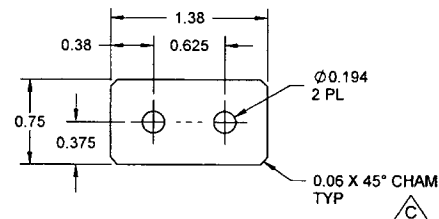


D3953-9 GAS SPRING WASHER



SECTION B-B 37-3

D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

RELEASED
2010-02-26

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CHECKED	<i>[Signature]</i>	DRAWING NO. REV: C
MFG. APPR.	<i>[Signature]</i>	D3953 SHEET 3 OF 4
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DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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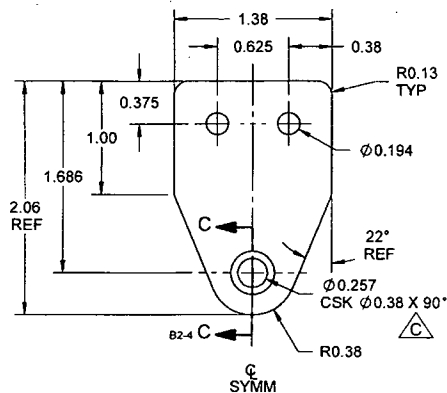
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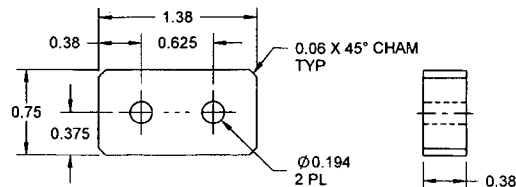
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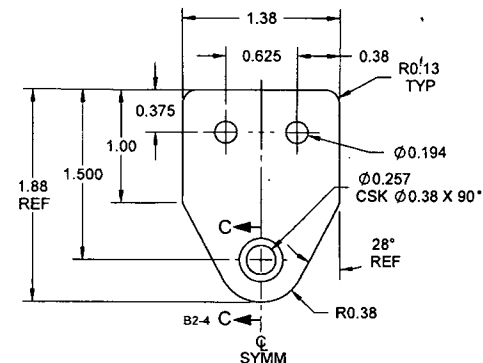
71270



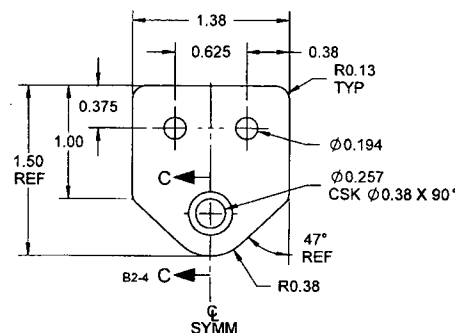
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



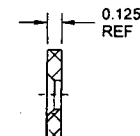
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



SECTION C-C

NOTES:

1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER





7) WEIGHT -15: 0.08 lbs

-17: 0.10 lbs

-19: 0.07 lbs

-21: 0.06 lbs

RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3953	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING LID COMPONENTS	NTS
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